

Date: Thursday, 04/09/2008 12:55:50 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WINDOW SEAL TOOL		
Job Number	: 41813		Part Number	: D35611		
Estimate Number	: 12558		Drawing Number	: D3561 REV.A		
P.O. Number	:		Project Number	: N/A		
This Issue	: 04/09/2008 S.O. No. :		Drawing Revision	: A		
Prsht Rev.	: NC		Material	:		
First Issue	: / / Type : SMALL /MED FAB		Due Date	: 11/09/2008 Qty: 5 Um: Each		
Previous Run	: 32210					
Written By	:					
Checked & Approved By	:					
Comment	: Est:A 06.10.19 New issue EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S11GA	304/316 0.125 Sheet	
		Comment: Qty.: 0.0497 sf(s)/Unit Total : 0.2483 sf(s) 304/316 .125 Sheet Batch: 108156 HB 8-9-5	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3561 Dwg Rev: A HB 8-9-5 Prog Rev: A	
		2-Deburr if necessary HB 8-9-5	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	
		Deburr if necessary.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		RC:						

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3561

SB 08/09/07

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/07 08/09/07

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 109

8/9/07

SO

9.0 QC21

FINAL INSPECTION/W/O RELEASE



08/09/10/07

Comment: FINAL INSPECTION/W/O RELEASE

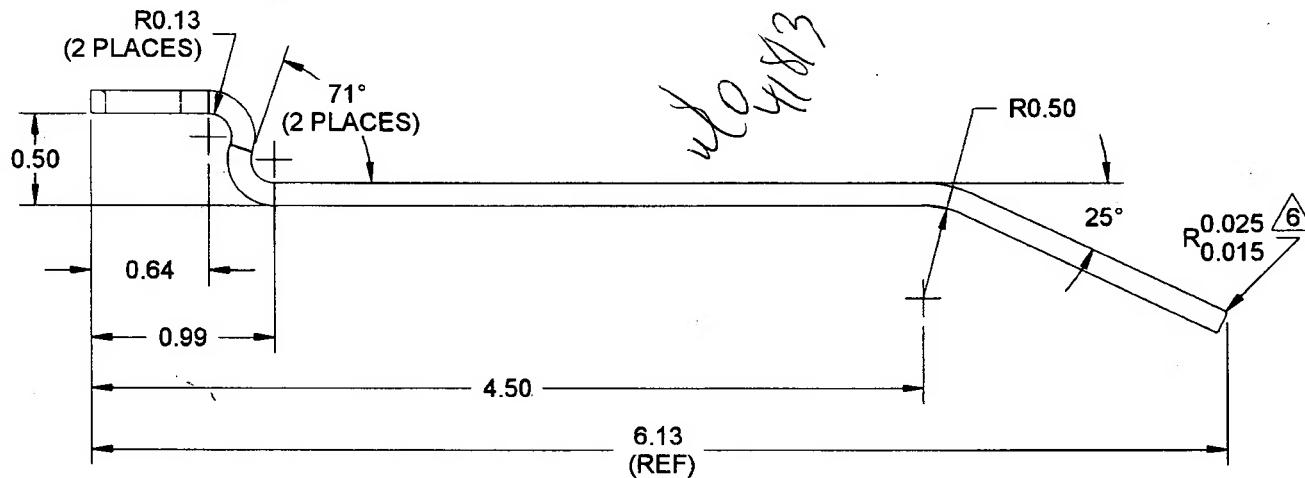
Job Completion



MF  
08-09-09

DESIGN 13	DRAWN BY <i>AS</i>	DART AEROSPACE LTD
CHECKED PH	APPROVED <i>AS</i>	HAWKESBURY, ONTARIO, CANADA
DATE 06.10.06	REV. A	DRAWING NO. D3561
DESCRIPTION NEW ISSUE		TITLE SEAL INSERT TOOL
DATE 06.10.06	REV. A	SCALE 1:1

**DART**

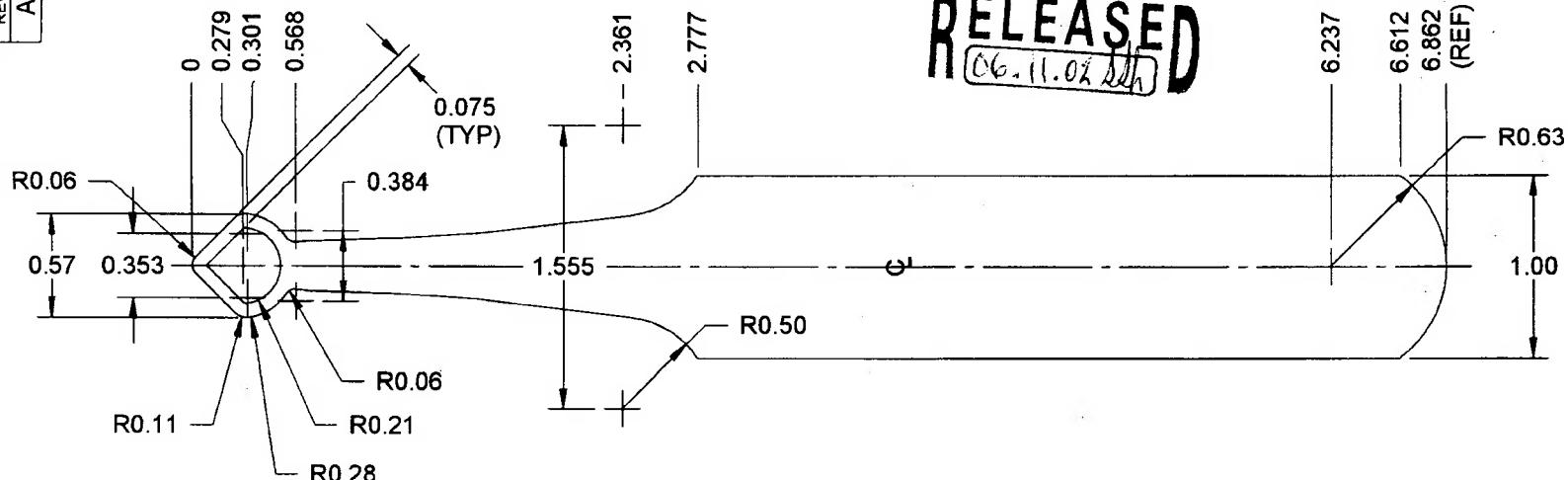


### D3561-1 SEAL INSERT TOOL

#### NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.125 THICK, PER MIL-S-5059 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S10GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP CORNERS 0.015 TO 0.025

**RELEASED**  
06.11.06



D3561-1F SEAL INSERT TOOL FLAT PATTERN

DART AEROSPACE LTD	Work Order:	41813
Description: WINDOW SEAL TOOL	Part Number:	D356(-1)
Inspection Dwg: D3561-1, Rev: A		Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## **X First Article      X Prototype**

Measured by:	HB	Audited by:	S	Prototype Approval:	N
Date:	8-9-5	Date:	de los	Date:	4

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	